

Work Order ID 51200

August 7, 2009 2:19:11 PM

Page 1

Item ID: D3266-041

Accept

Setup Start

Revision ID: B

Stop

Item Name: Basket Lid Assembly

Start Date: 8/10/09 Start Qty: 1.00

Cust Item ID:

Required Date: 8/21/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3266

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut (4) D2236 From D3166-3 12-Cut 3/4" x 3/4" square tubing as per Dwg D3266 13-Drill holes in D3266-1 as per Dwg D3266 using Drill Jig DT8305
4-Deburr & Remove all markings from material 15-Weld as per Dwg D3266 using Welding Table and corner Jig De

09.08.17

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

09.08.18

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Page 2

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Start Date: 8/10/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/21/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00							
130 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo IST COAT: <input type="checkbox"/> START TIME: _____ <input type="checkbox"/> OVEN TEMPERATURE: _____ <input type="checkbox"/> FINISH TIME: _____ <input type="checkbox"/> 2ND COAT: <input type="checkbox"/> START TIME: _____ <input type="checkbox"/> OVEN TEMPERATURE: _____ <input type="checkbox"/> FINISH TIME: _____	0.00 0.00							
140 HandFinish Hand Finishing	HandFinishing Memo Wing WalkBatch: _____ <input type="checkbox"/> and Spray Paint black Batch: _____ <input type="checkbox"/> as per Dwg D3266and QSI 005 4.4	0.00 0.00							

DO NOT PAINT-ENG

SEE ATTACHED EMAIL

L Lacelle

From: Mike Petsche [mpetsche@dartaero.com]
Sent: August 7, 2009 11:42 AM
To: 'L Lacelle'; 'Melanie Fauteux'
Cc: 'Alan Stocker'; 'Dan Stow'
Subject: Two basket lids

Mel/Linda

Por favor...

We need two AS350 basket lids. We need a SHORT basket – full lid, and a Long Basket Split Lid....We'll try to be careful with them so that they can be returned to inventory when we're done....(not powder-coated)

No hurry.....sometime in the next couple of weeks.

Thanks

Mike Petsche
Design Manager
DART Aerospace
phone: 613-632-5200
mobile: 514-833-1657
skype: mike.petsche

8/07/09

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Item ID: D3266-041

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Stop



Item Name: Basket Lid Assembly

Start Date: 8/10/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/21/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
160	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

RD0308
W10:03.11

Picklist Print

August 7, 2009 2:19:11 PM

Page 1

Work Order ID: 51200

Parent Item: D3266-041RevB

Parent Item Name: Basket Lid Assembly



Comments:

Start Date: 8/10/09

Required Date: 8/21/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2232-1RevC  Basket Hinge		Manufactured	No			100	Each	22.0000	2.0000 			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2

48230

2

Main Warehouse

WA

20

50896

20

D2327-1RevD



Spacer Bushing

Manufactured No

100

Each

6.0000

2.0000


Cpl 09-08-11

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

6

46325

6

D2506RevF



Label Plate

Manufactured No

100

Each

3.0000

1.0000


Cpl 09-08-11

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

3

44275

1

50027

2

51135

Cpl 09-08-11

Picklist Print

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Work Order ID: 51200

Parent Item: D3266-041RevB

Parent Item Name: Basket Lid Assembly


Comments:

Start Date: 8/10/09

Required Date: 8/21/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1  Mounting Bracket		Manufactured	No			100	Each	49.0000	2.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5	
46086	2	
48428	3	
Main Warehouse		
WA	44	
50872	44	

D3166-3RevA1

Manufactured

No

100

Each

6.8105

1.0000



Basket Hoop

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	6.8105	
50033	0.8105	
50618	6	

CP-09-08-11

SAN 09-08-11

IX SAN

Picklist Print

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Parent Item: D3266-041RevB



Parent Item Name: Basket Lid Assembly

Start Date: 8/10/09

Required Date: 8/21/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	718.7735	10.0000			



Expanded Metal Flat SS



SAD 09-08-11



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	718.7735065	
108152	90	
110134	6.7	
110292	14.4	
110629	14.41	
110861	21.18	
110992	0.58	
111444	4.14	
111630	9.15	
111956	4.335517	
112147	105.877989	
112311	448	

10.000

Picklist Print

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Parent Item: D3266-041RevB



Parent Item Name: Basket Lid Assembly

Start Date: 8/10/09

Required Date: 8/21/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			100	f	609.5362	28.4211			



304 SQ Tube .75x.75x.065W

+ 9 ask chanta/
Sad 09-08-11

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

9.536213691

111148 /

0.484

111432 /

0.44

111885 /

1.5682

112051 /

7.3691E-05

→ 112263

7.04394

+adj

28.4211

Main Warehouse

WA

600

112344

600

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Shop Packet Print

Page 4

QTY -041	PART NUMBER	DESCRIPTION
X	D3266-041	BASKET ASSEMBLY
2	D2232-1	HINGE PLATE
4	D2236	RIB
2	D2327-1	BUSHING
1	D2506	LABEL PLATE
2	D2581	MOUNTING BRACKET
2	D3266-1	RIB
2	D3266-3	RIB
6	D3266-5	RIB
3	D3266-7	RIB

all
51200

RELEASED
08-09-04/11



NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

B	INCORPORATED A1. DRAWING UPDATED TO CURRENT STANDARDS. SHEET 5 ADDED. RIB MATERIAL WAS 0.060 THICK.	AJS	08.08.15
A	NEW ISSUE	CP	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PM	DRAWING NO.	REV. B
MFG. APPR.	FE	D3266	SHEET 1 OF 5
APPROVED	FE	TITLE	SCALE
DE APPR.	FE	BASKET LID ASSEMBLY (350)	NTS
DATE	08.08.15	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

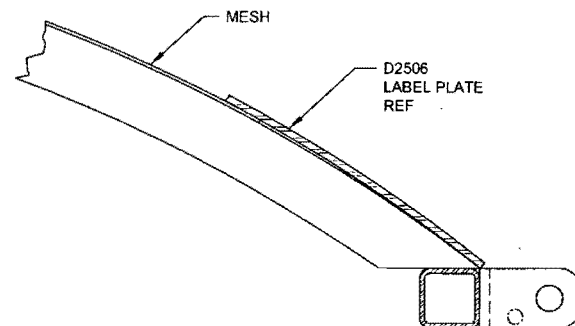
8 7 6 5 4 3 2 1

D

C

B

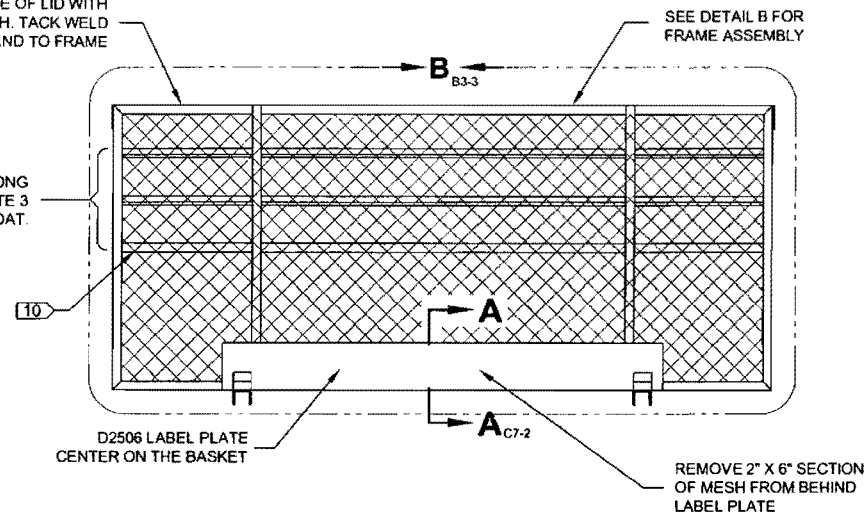
A



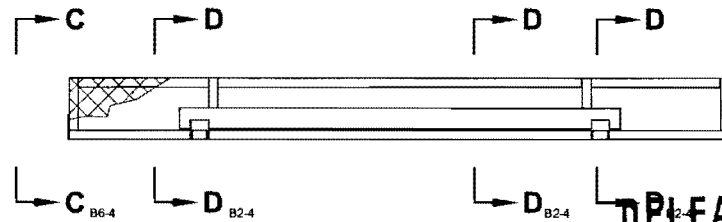
SECTION A-A
(ROTATED 90° CCW)
SCALE NONE

SKIN OUTSIDE SURFACE OF LID WITH
SS MESH. TACK WELD
EACH END STRAND TO FRAME

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.



D3266-041 BASKET LID ASSEMBLY



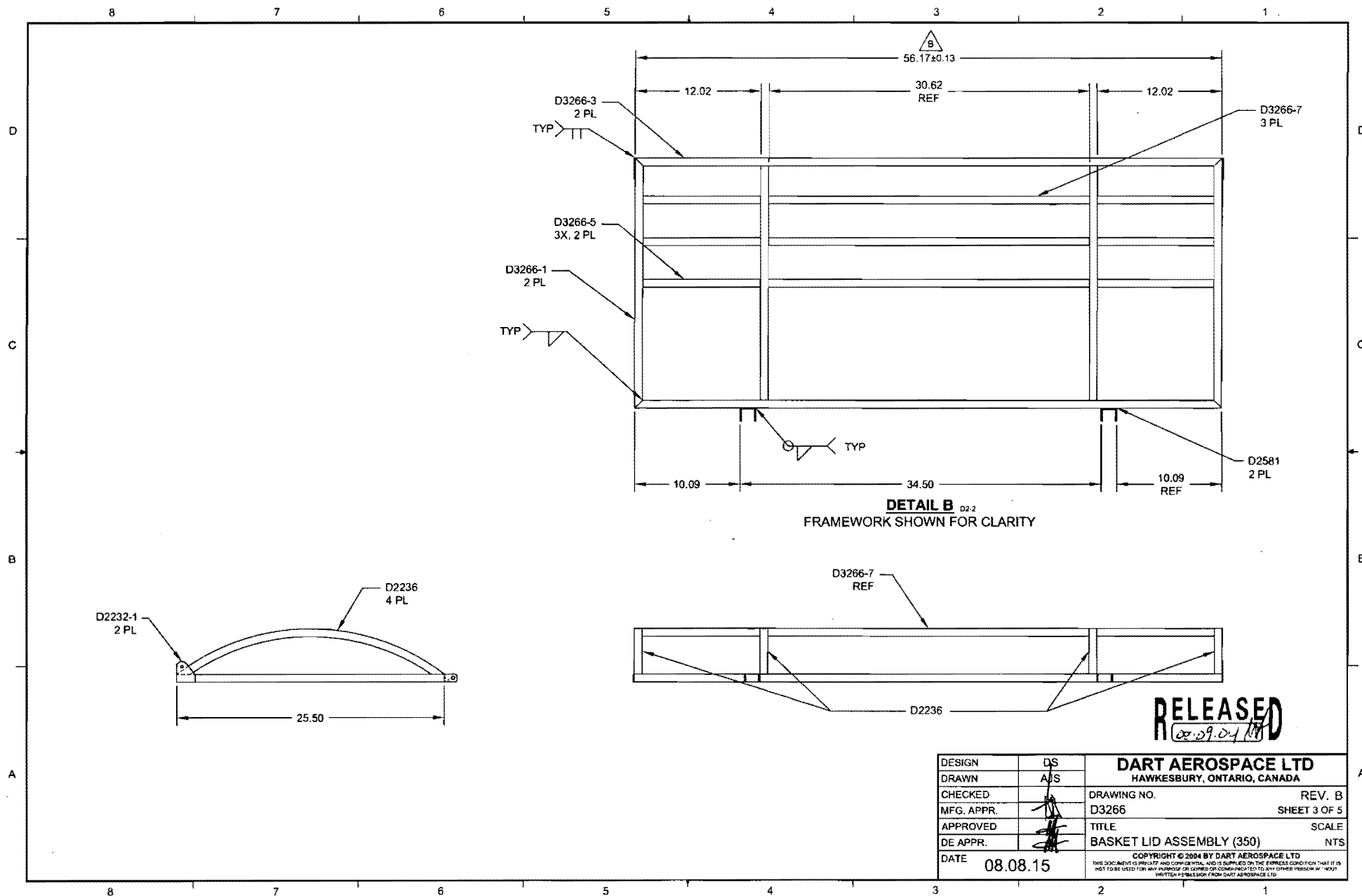
ASSEMBLY NOTES:

- 1) MATERIAL: SEE SHEET 1
- 2) FINISH: FOR OVERALL FINISH SEE SHEET 1
- 3) FINISH: SPRAY PAINT BLACK INSIDE SURFACE AFTER POWDER COAT
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE
PER DART QSI 005 4.4 AFTER POWDER COAT
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004
- 10) TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION

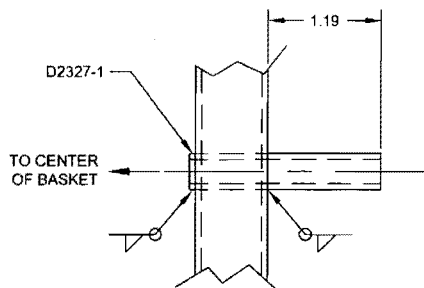
RELEASED
08-04-15

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3266	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350)	NTS
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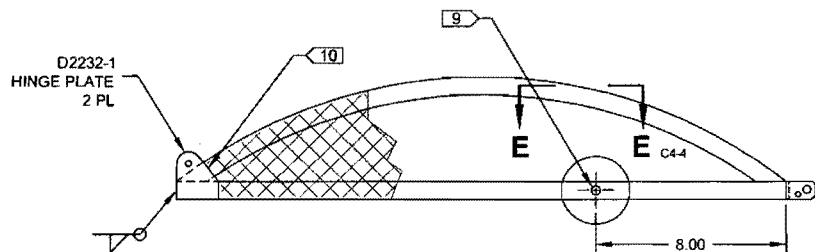
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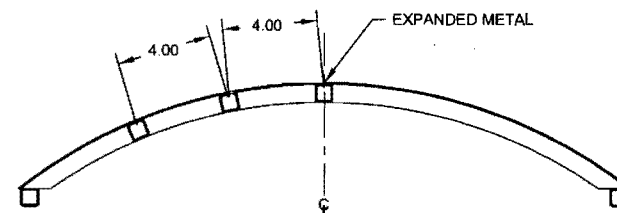
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VIEW E-E B4-4
SCALE 4X
(BOTH ENDS)



SECTION C-C A4-2
(BOTH ENDS)



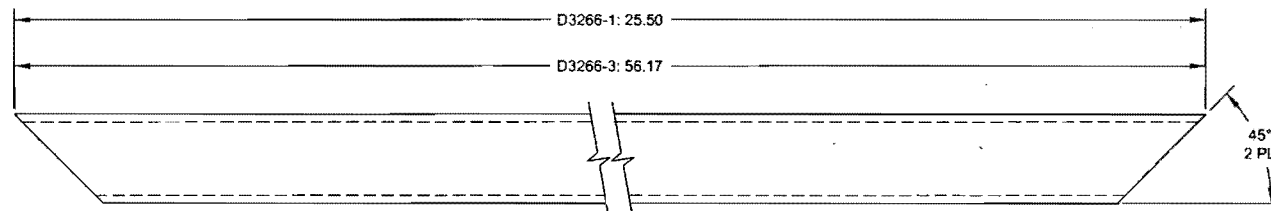
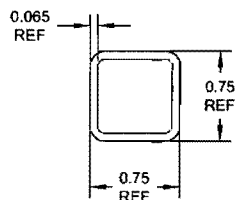
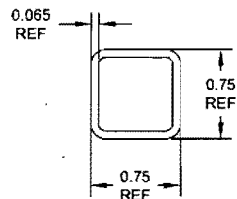
SECTION D-D A1-2
A2-2
A3-2
3 PL

NOTES:

- 1) MATERIAL: SEE SHEET 1
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DRILL 3/8 HOLE AND INSTALL D2327-1 USING CLOSEST SPACE IN EXPANDED METAL FOR HOLE LOCATION BOTH ENDS
- 10) TRIM MESH AS REQUIRED TO ALLOW D2327-1 HINGE PLATE TO SIT FLUSH ON FRAME

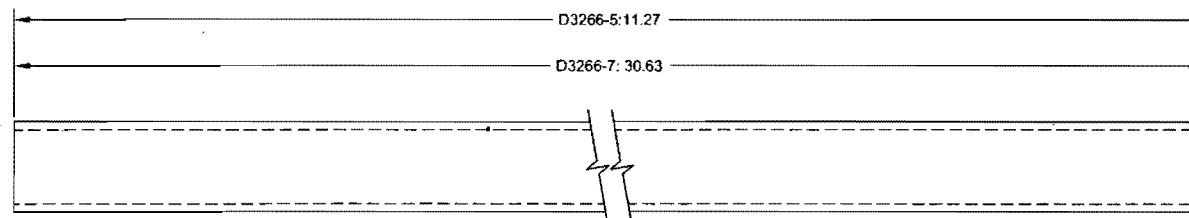
RELEASED
08 09 04 15

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RT	DRAWING NO.	REV. B
MFG. APPR.		D3266	SHEET 4 OF 5
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D3266-1 RIB

D3266-3 RIB



D3266-5 RIB

D3266-7 RIB

RELEASED
02-09-01-17

RIB NOTES:

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	PA	DRAWING NO.	REV. B
MFG. APPR.	AS	D3266	SHEET 5 OF 5
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